

108652

October-25-13 2:26:46 PM

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 10/25/13 **Start Qty:** 12.00 ***12***

Cust Item ID:

Required Date: 10/29/13 **Req'd Qty:** 12.00 ***12***

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

**Insp.
Stamp**

0.00

120

0.00 **DAS**
27
9-89

QC

Memo

Quality Control

13. 10 28

0.00

130

Small Fab

0.00

Small Fab

Memo

Small Fab

Deburr

DAS
27
9-89

0.00

140

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

Quality Control

Work Order ID 108652

108652

Page 3

October-25-13 2:26:46 PM

Item ID: D3210-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Doubler For Interior Window -015 & -025

Stop ***NS2***

Start Date: 10/25/13 Start Qty: 12.00

12

Cust Item ID:

Required Date: 10/29/13 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Chemical Conversion Coat per QSI005 4.1	0.00							
150									
HandFinish	Memo	0.00							
Hand Finishing									
155	QC7-Inspect Chemical Conversion Coat	0.00							
155									
QC	Memo	0.00							
Quality Control									
160	Black Sandtex(Ref 4.3.5.7) per QSI005 4.3	0.00							
160									
Powdercoat	Memo	0.00							
Powder Coating									
	START TIME: 1:00 OVEN TEMPERATURE:								
	FINISH TIME: 1:30								

12 11/10/13

12 13-10-31 DAS 34 9-89

12 13-10-31 DAS 34 9-89

Work Order ID 108652

October-25-13 2:26:46 PM

108652

Page 4

Item ID: D3210-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Doubler For Interior Window -015 & -025

Start Date: 10/25/13 Start Qty: 12.00 ***12***

Cust Item ID:

Required Date: 10/29/13 Req'd Qty: 12.00 ***12***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	QC3- Inspect Part Finish	0.00							
170									
QC	Memo	0.00				12			
Quality Control									
180	Identify as per dwg & Stock Location: <u>5T210</u>	0.00							
180									
Packaging	Memo	0.00				12x			
Packaging									
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							
Quality Control									

DAS
28
9-89

13-11-1

[Signature] 13-11-05

13-11-01

Picklist Print

October-25-13 2:26:46 PM

Page 1/1

Work Order ID: 108652

Parent Item: D3210-1

Parent Item Name: Doubler For Interior Window -015 & -025

Start Date: 10/25/13

Required Date: 10/29/13

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A New Issue 05-11-17 JLM
IPP Rev:B Now On Waterjet 06-10-24 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M2024T3S.080
2024-T3 .080 sheet

Purchased No

100 sf 103.1700

1.7

22

Jm13-10-26

Location

Loc Qty

Loc Code

MAT022

103.17

123217

27.75

125636

25.92

M126161

49.5

126161

DART AEROSPACE LTD		Work Order:	108652
Description: Doubler		Part Number:	D3210-1
Inspection Dwg: D3210	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

[illegible]

DAS		DAS	
Measured by: JM	Audited by: 27 9-89	Preliminary Approval:	
Date: 12-10-26	Date: 12-10-28	Date:	

Rev	Date	Change	Revised by	Approved
A	03.12.15	New Issue P/O D350-567-015/-025/-031	KJ/RF	
B	04.06.15	Removed 14.607 dimension	KJ/JLM	
C	12.10.26	Dwg Rev updated	KJ	

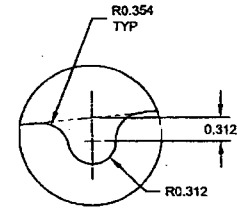
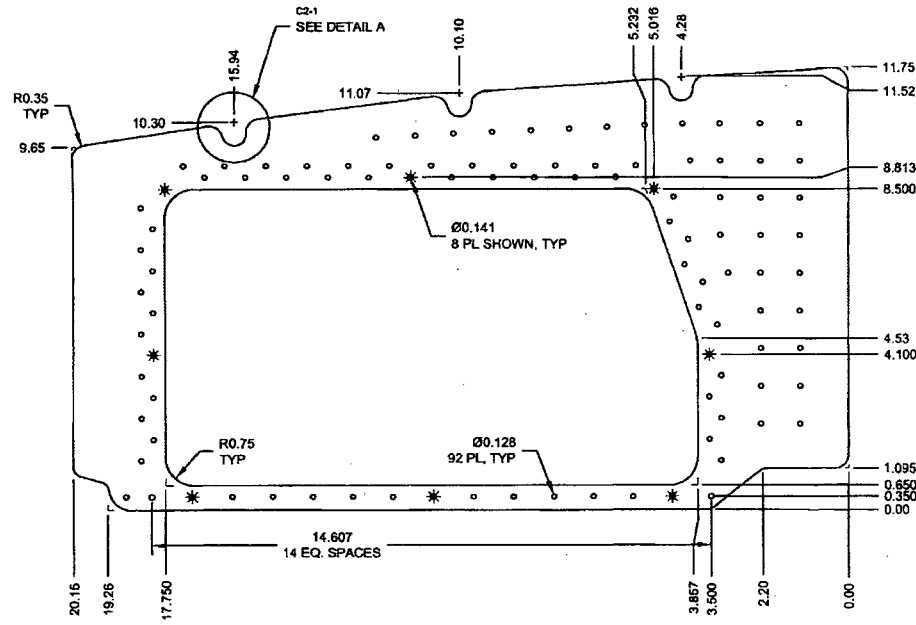
8 7 6 5 4 3 2 1

D

C

B

A



DETAIL A
SCALE 2X, 3 PL

no 108652

RELEASED
2011-06-14

D3210-1 DOUBLER

D3210-1 NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.080 THICK, PER QQ-A-250/4 OR AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209 REF. DART SPEC M2024T3S.080
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT "BLACK SANDING" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3210-1" AND B/N "BXXXXX" PER QSI 044 6.1
- 7) WEIGHT: 0.86 lbs
- 8) MAKE PER "D3210-1_REV.B.DXF"

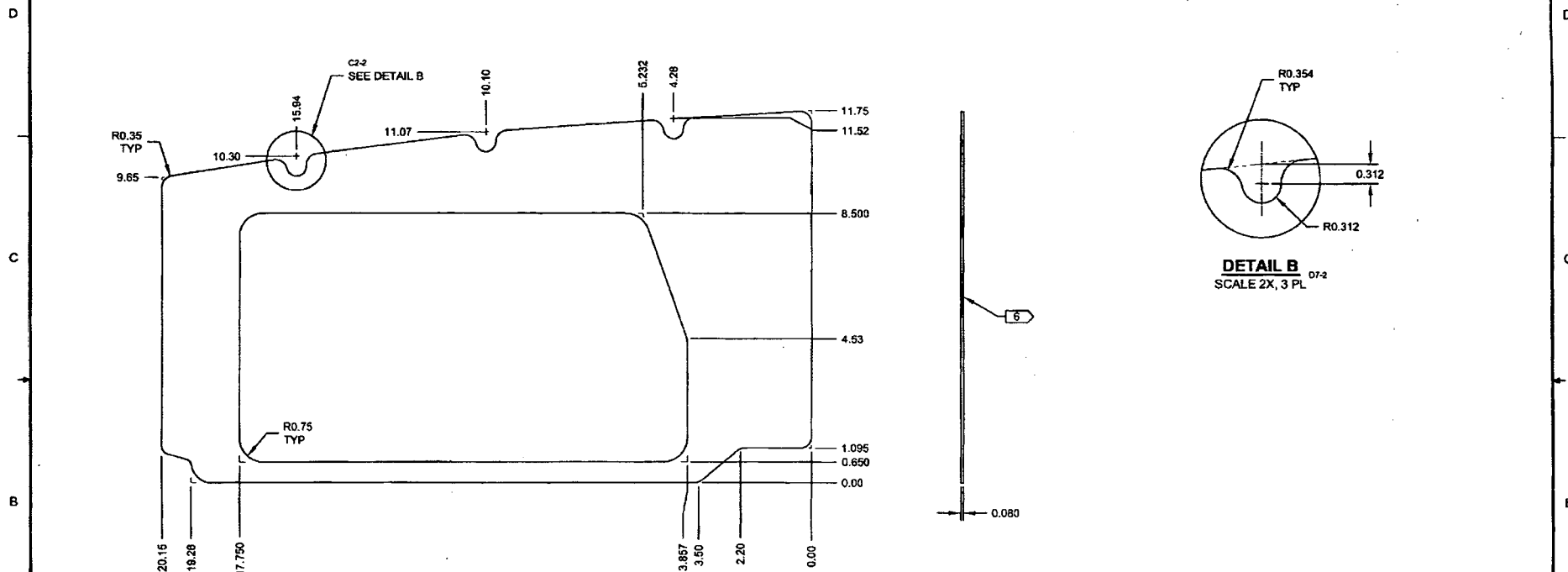
B	FORMAT TO CURRENT STD; ADD D3210-1B. REASON: PAR11-109.	MB	11.06.03.
A	NEW ISSUE	CP	03.09.03
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.06.03		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3210-1
TITLE DOUBLER
REV. B
SHEET 1 OF 2
SCALE NTS
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8 7 6 5 4 3 2 1

8 7 6 5 4 3 2 1



D3210-1B BLANK DOUBLER

RELEASED
2011-06-14

D3210-1B NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.080 THICK, PER QQ-A-250/4 OR AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209 REF. DART SPEC M2024T3S.080
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT "BLACK SANDEK" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3210-1B" AND B/N "BXXXXX" PER QSI 044 6.1
- 7) WEIGHT: 0.87 lbs
- 8) MAKE PER "D3210-1B_REV.B.DXF"

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3210	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		DOUBLER	NTS
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8 7 6 5 4 3 2 1

